Work Order ID 6322 Monday, October 25, 2010, 12:4						SWP	Fri	day	>	Page 1
Item ID: D044-713-014 Revision ID: Item Name: Bubble Window,	DП	Ac	ecept				se se	etup Start Stop	1 19911181 91	
Start Date: 10/25/2010 S	Start Qty: 7.00 Req'd Qty: 1.00	188 10 1 10 188 188 188		Cust Item II Customer:	D:				1 100111101 51	
Approvals: Process Plan: QC:		Date: <u> () </u>	Fooling:		te:		R	un Start Stop		
=	Peration Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr Revisi N/A Rev N	on Nbr									
100	OCCUMENT CONTROL Memo		0.00				M.	Cos B	G 10-	10-25
Document Control	Photocopy bluef	iles and create labels per F H (7003) PE	PP D044-713-014 & : 2 ECN 1131 (DSI 9329 SEE ATTACHOOD PAGE) iol.	U 27				
	ick Kit						10	10/25	- (3	
Packaging Packaging	Memo		0.00							9 — 1/-
	C4-100% Inspect kits for c	ompleteness	0.00	\ \ \ \						
QC Quality Control	Memo		0.00	16/12>			CIS.			

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W/O:			W	ORK ORDER CHAN	IGES		 			*						
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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Part No	:	PAR #:	Fault Cat	egory:	NCF	R: Yes 1	10 DQ	۸:	Date:							
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DATE	OTED	Description of NC		ection B		Verific	ation	Approval	Approval							
DATE	STEP	Section A	Initial Chief Eng	n .	Sign & Date	Section C		Chief Eng	QC Inspector							
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Work Order ID 63223

Monday, October 25, 2010 12:49:26 PM



Page 2

Item ID:

D044-713-014

Accept

Setup Start

Stop

Stop

Revision ID:

Item Name:

Bubble Window, RH

Start Date:

10/25/2010

Start Qty: 1.00

Reg'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Date:

Run Start

Qty



Required Date: 10/29/2010

Date:

SPC (Y/N):

Date:

Tool ID

Tool # Plan

Code

Accept Qty

Reject Reject Number

Insp. Stamp

Work Center ID 130

Sequence ID/

Packaging

Packaging

Operation Description

Packaging

Set Up/ **Run Hours**

0.00

0.00

Memo

Identify and pack for shipping as per PPP D044-713-014

Location:

PPP Rev:

140

Quality Control

QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANGE	S			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date (Qty Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section		Verificat	tion Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date			QC Inspector
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Picklist Print

Monday, October 25, 2010 12:49:26 PM

Work Order ID: 63223

Parent Item:

D044-713-014

Parent Item Name:

Bubble Window, RH



Start Date: 10/25/2010

Required Date: 10/29/2010

Page 1

Start Qty: 1.00

Required Qty: 2,00

Comments:

IPP Rev:A□05.03.22□New issue□KJ/JLM□

IPP Rev:A□06-07-03□As per DSI 9329 JLM□

IPP Rev:C 08-07-30 chg qty DD verified by:EC

				ou oy.bo									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8720		Manufactured	No			110	Each	0.0000	1. <u>`</u>	13/0/	11/25		
D2126 (on meno	Manufactured	No			110	f	232.6234	7.525	7.921053 1010	125	\mathcal{O}	
	·			Location	•	Loc (Loc Code				•	
D2270.2	•				48285 57106		.535			374	- - -		
D3269-2		Manufactured	No			110	Each	0.0000	1	63	,158	(2)	1/1/27
D3312-1		Manufactured	No			110	Each	9.0000		10/10/	3 5 .		Be
•	1			Location		Loc (<u>Oty</u>	Loc Code				-	
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					28101		9)	_		

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W/O:			WO	RK ORDER CHANC	SES					7
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Part No	:	PAR #:	Fault Categ	jory:	_ NCR:	Yes N	o DQ	\ :	_ Date: _	
	R	esolution:	Disposition): <u></u>	QA: I	WC Clos	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC			tion B	0:	Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
								··· -· -· ·	-	·
1	1		1 1		1		I		1	1

Change Record

Part Number 1044-713-014
Description BUBBLE WINDOW KIT, RH

Page _____ of _____

Chg.	Date 05.03.24	By A	Relevant Documents
001	05.03.24	1	PER DR-DO44-7136000 Rev. C
		10	
002	06.06.30	IR W	PER DR-D044-713 REV D AND DS1 9329 BEV B PER DR-D644-713 Rev. F A D3269 Rev. D, FCN 1131
			AND DS1 9329 BEV B
603	08.02.15	P	PER DR-NAUL-712 Part
			1 D22 19 Run FC 1131
-			PCN IISI
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Part No) :	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
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DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	& Secti	Section C Chief Eng		QC Inspector
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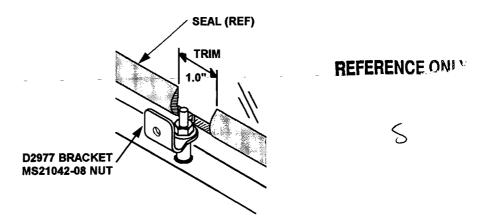


FIGURE 4 - D044-713-015 Passenger Door Window Kit - Tab Installation

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

		LA	TERAL	LONGITUDINAL		
Installation	Weight	Arm	Moment	Arm	Moment	
D044-713-011	1.5 lb	±24 in	±36 in-lb	66 in	99 in-lb	
Crew Door Window Kit	0.68 kg	±0.61 m	±0.43 m-kg	1.68 m	1.1 m-kg	
D044-713-013	2.5 lb	-28 in	-70 in-lb	66 in	165 in-lb	
Bubble Window Kit, LH	1.1 kg	-0.71 m	-0.78 m-kg	1.68 m	1.8 m-kg	
D044-713-014	2.5 lb	+28 in	+70 in-lb	66 in	165 in-lb	
Bubble Window Kit, RH	1.1 kg	+0.71 m	+0.78 m-kg	1.68 m	1.8 m-kg	
D044-713-015 Passenger Door Window Kit	1.2 lb	±23 in	±28 in-lb	83 in	100 in-lb	
	0.54 kg	±0.58 m	±0.31 m-kg	2.11 m	1.1 m-kg	

5.0 PARTS LIST

Qty	Qty	Qty	Qty		
-011	-013	-014	-015	Part Number	Description
Х				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	Х	i		D044-713-013	BUBBLE WINDOW KIT, LH
		Х		D044-713-014	BUBBLE WINDOW KIT, RH
			Х	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
			1	D2126-0720	SEAL
1	1	⁻ 1 ⁻		D2126-0903 •	SEAL
	1			D3269-1 .	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
	1	1		D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
		÷	⁻ *1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

^{*} Not to be installed. Cutting template only.

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Revision: A

Date: 05.01.10